

Date: • Wednesday, 25/06/2008 12:00:03 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 40087B	
Estimate Number : 10354	
P.O. Number :	Part Number : D2322
This Issue : 25/06/2008 S.O. No. :	Drawing Number : D2322 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 37925B	Material :
Written By :	Due Date : 07/07/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.6.25</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total : 2.5578 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: 109572 HB 8-7-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: C
 Prog Rev: C

HB 8-7-3

2-Deburr if necessary

HB 8-7-3

(14)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-7-3**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 08/07/08 NC

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D2322

S 08/07/07 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 25/06/2008 12:00:03 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 40087B

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/08 (14)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-07-08 (14)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 8/7/8 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *store*

PC 8/7/8 (14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10 (14)

Job Completion



cmf 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
BW	CP	DRAWING NO.	D2322	REV. C
CHECKED KE	APPROVED [Signature]	TITLE	STEP SPACER	SHEET 1 OF 1
DATE 98.09.29		SCALE	1:2	
A	94.10.14	NEW ISSUE		
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001		

RELEASED
98.10.08 DS

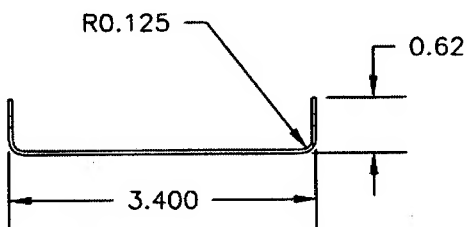
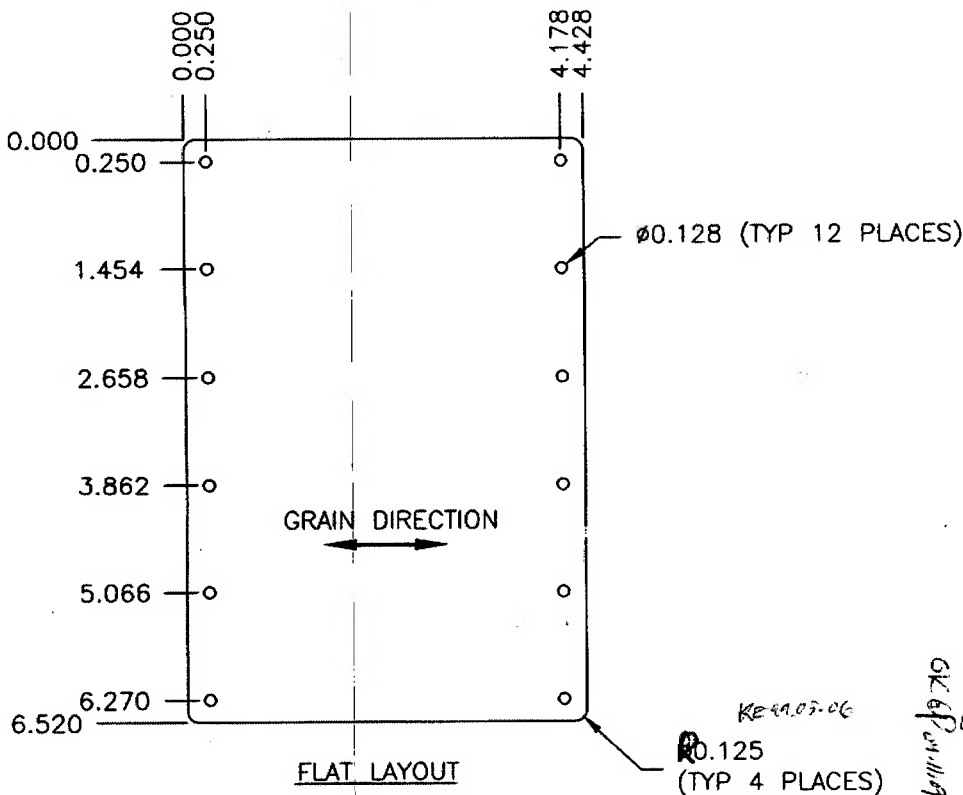
UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

OK CP 01/11/99

KE 98.07.06



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 400878